

Work Order ID 57600

Page 1

Friday, April 09, 2010 1:32:44 PM

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 4/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 10-4-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3929	Rev A

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

10-4-17

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: B

2-Deburr if necessary

(7)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

10-4-17

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Page 2

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Run

Start



QC:

Date:

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Date:

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Sequence ID/
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S100412



QC

Memo

0.00



Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00



Packaging

140

Memo

0.00



Large Fab

Weld bushings D3907-1 as per dwg D3929

0.00



Large Fab

316L rod batch: 111679

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Page 3

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

S. Colucci



QC

Quality Control

170

Identify as per dwg & Stock Location: B/C

0.00



Packaging

Packaging

Memo

0.00

(7) PD 10.04.21

(X7)

(C7)

(7)

JPL 10.04.21

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Page 4

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QC:

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Date:

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/21 AF
MF
10-4-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, April 09, 2010 1:32:44 PM

Page 1

Work Order ID: 57600



Parent Item: D3929-041



Parent Item Name: Gusset Assembly

Start Date: 4/12/2010

Required Date: 4/15/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased		No		100	sf	33.8200	2.8421	3.4 	HB10-4-12	

304/316 0.125 Sheet

D3907-1



Bushing

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT19 33.82

112663 33.82

112663

130 Each 59.0000 12.0000

⑦

PCL10.04.20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA 59

56517 18

57242 41

④

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DART AEROSPACE LTD	Work Order:	
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-4-17	Date:	10/04/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.27	New Issue P/O D3929-041/-042	KJ	

8

7

6

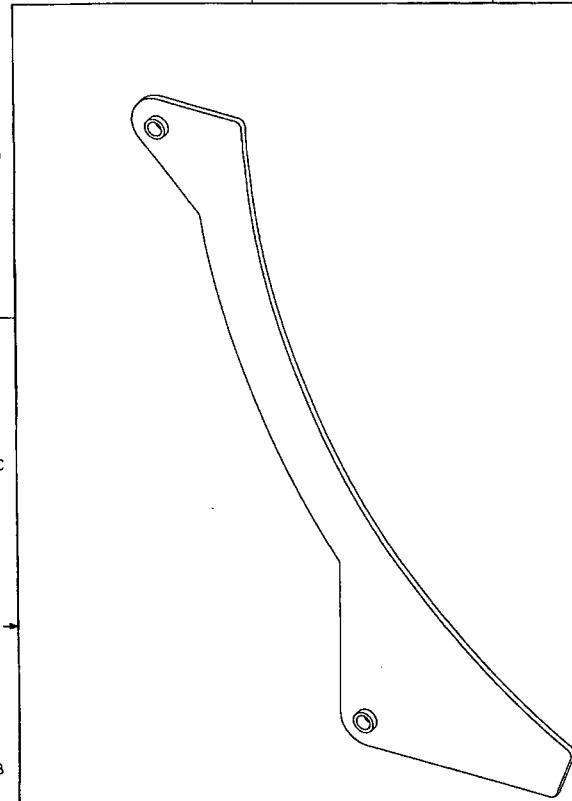
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4

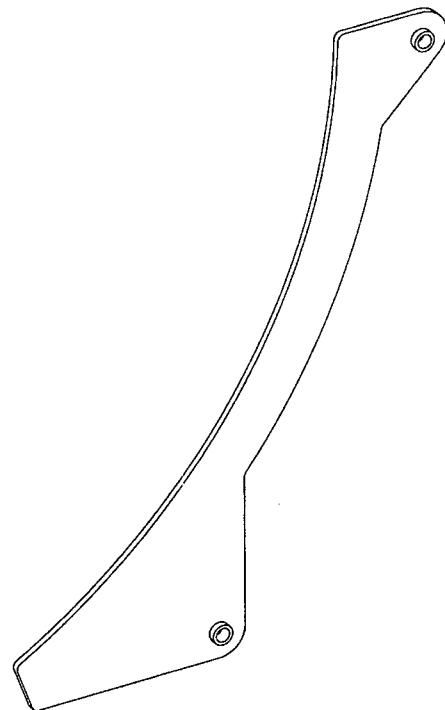
3

2

1



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY 041	QTY 042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

AS 7600

RELEASED
07/04/11

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

8

7

6

5

4

3

2

1

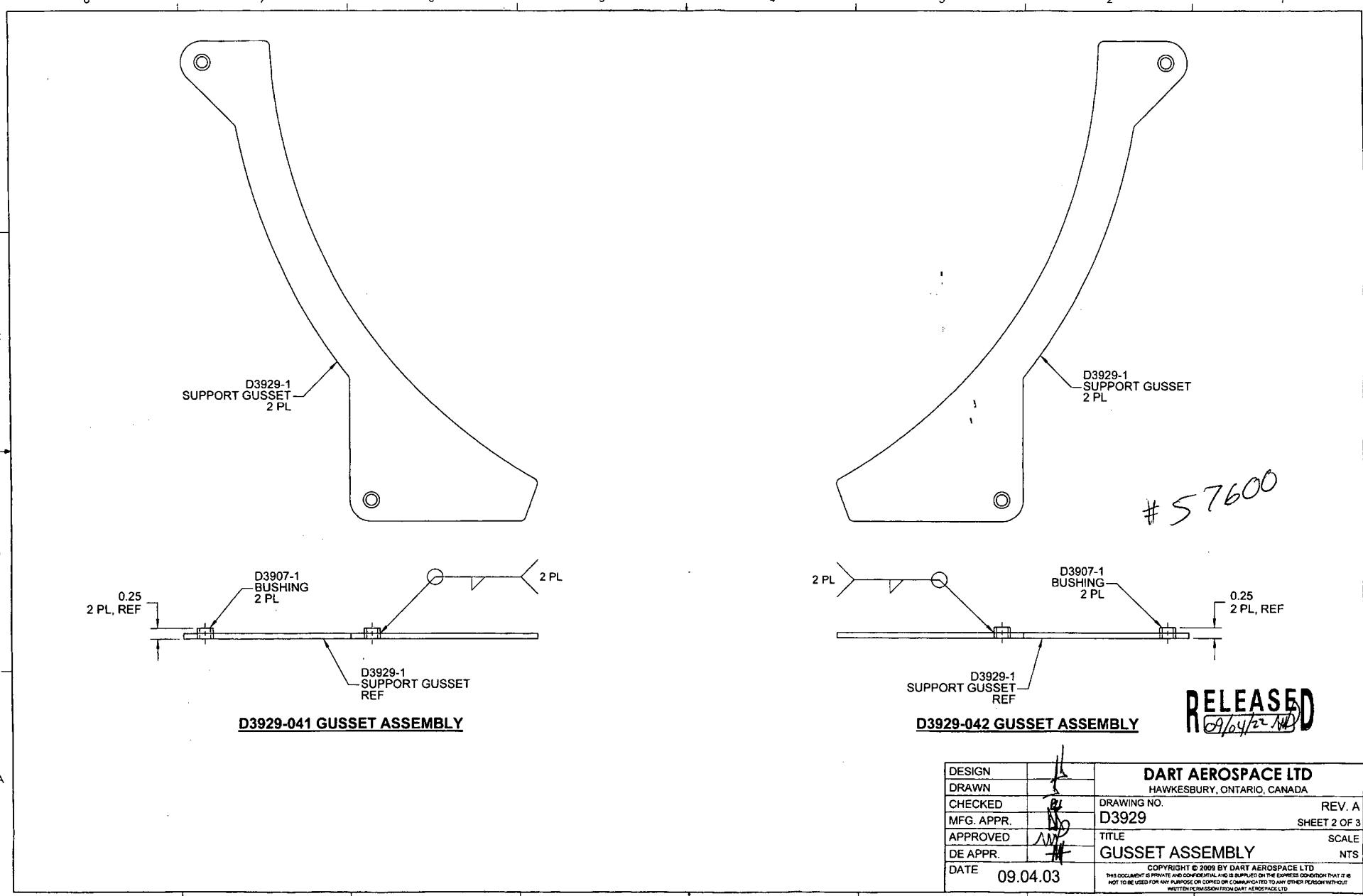
A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PK</i>	DART AEROSPACE LTD	
DRAWN	<i>PK</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PK</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PK</i>	D3929	SHEET 1 OF 3
APPROVED	<i>PK</i>	TITLE	SCALE
DE APPR.	<i>PK</i>	GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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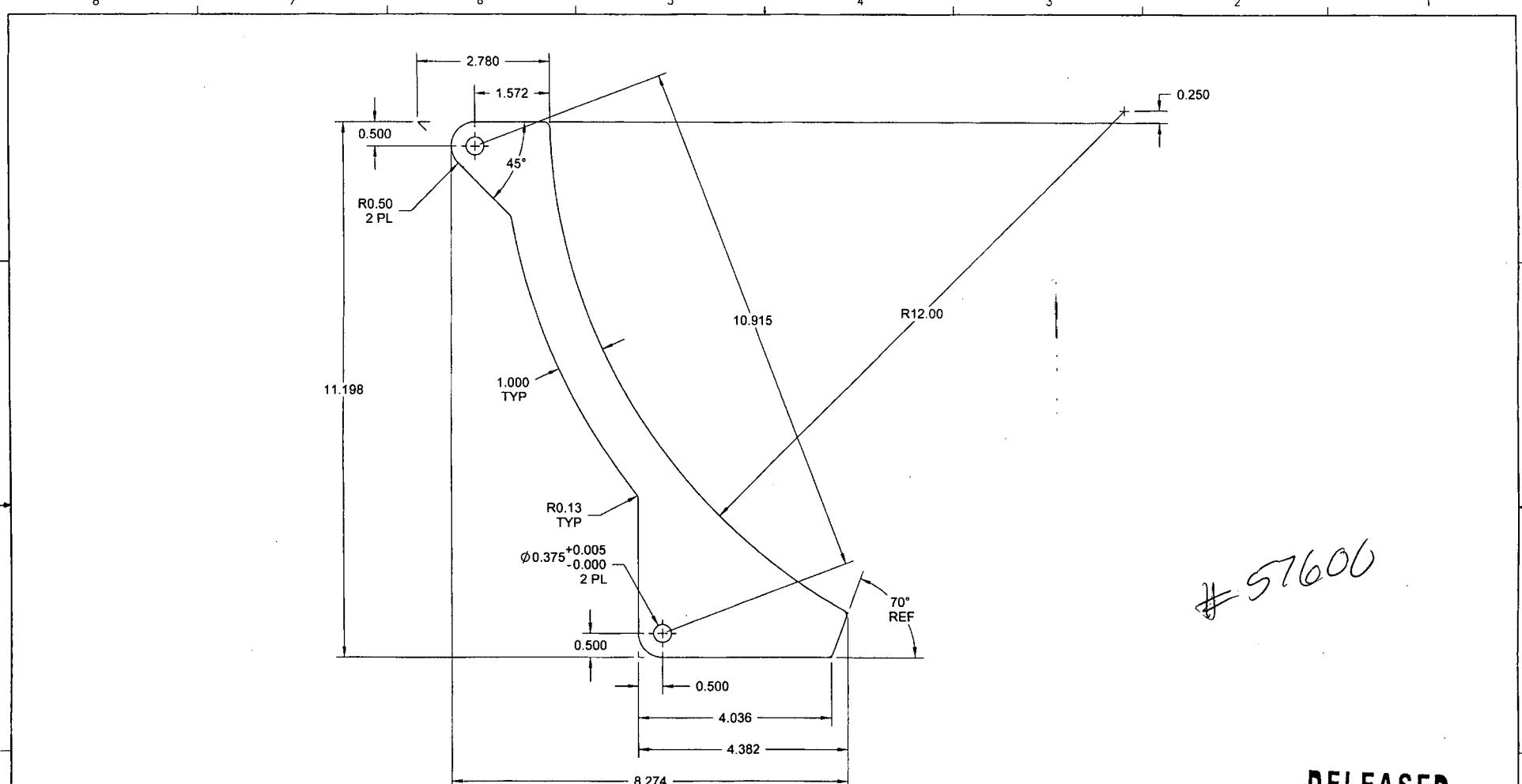


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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3929
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	SHEET 3 OF 3
DE APPR.	<i>[Signature]</i>	TITLE GUSSET ASSEMBLY
DATE	09.04.03	SCALE NTS

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